

Work Order ID 83878

83878

Page 1

April-26-12 2:36:37 PM

Item ID: D3414-3 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lug
 Start Date: 26/04/2012 Start Qty: 60.00 *60* Cust Item ID:
 Required Date: 10/05/2012 Req'd Qty: 60.00 *60* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/27 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3414	Rev C

100 0.00
 100 12-5-01 60
 Bandsaw Memo
 Jeaspa Bandsaw Cut blanks: 2.50" x 0.500" x 2.250" long

110 0.00
 110 Purdum 02 12/05/03 60
 HAAS Memo
 HAAS CNC vertical machine #1 Machine as per Folio FA569 and Dwg D3414
 Identify as D3414-3Dwg Rev Folio Rev issue P/O A.T.G. P/O: 16887

120 0.00
 120 QC 58x 896
 Quality Control Memo
 QC2- Inspect parts off machine FAI/FAIB
 Machine as per drawing D3414 REV.C
 12-5-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

April-26-12 2:36:37 PM

83878

Page 2

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 26/04/2012 **Start Qty:** 60.00

60

Cust Item ID:

Required Date: 10/05/2012 **Req'd Qty:** 60.00

60

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

QC₂ - Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

Identify as per dwg & Stock Location WA

0.00

140

Packaging

Memo

0.00

Packaging

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MLJ 12705/28

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Picklist Print

April-26-12 2:36:41 PM

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Work Order ID: 83878

83878

Parent Item: D3414-3

D3414-3

Parent Item Name: Lug

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.500X2.500 Purchased No

100 f 36.4970 0.1875 11.25

M304B0 500X2 500

**

304 BAR .500 x 2.50

58x SP 12-5-28

Location

Loc Qty

Loc Code

MAT050

36.497

112764

8.312

116135

0.375

117685

4.4

119231

23.41

4
8

12-5-01
12-5-01

D3414-3P

X60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

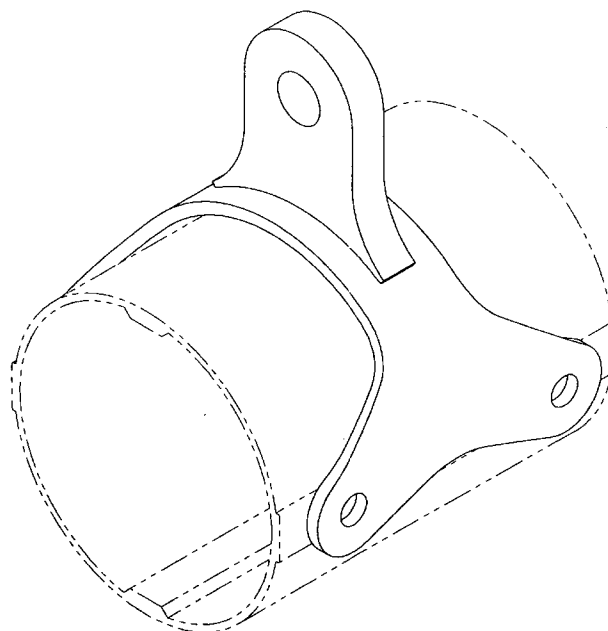
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NOTE: Date & initial all entries

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83878 MJS
12/04/27

RELEASED
3/10/2017

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -3 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
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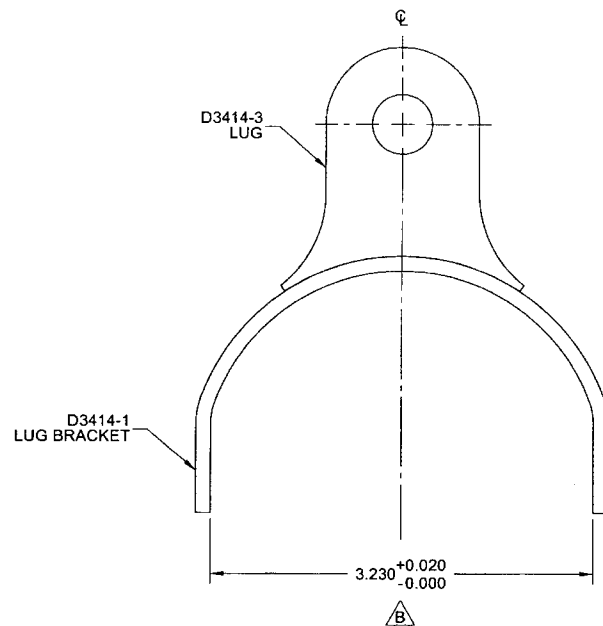
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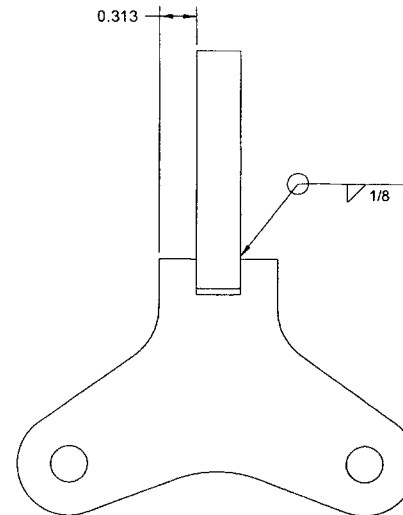
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

03870



D3414-041 LUG ASSEMBLY



RELEASED
09/06/17

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 2 OF 3
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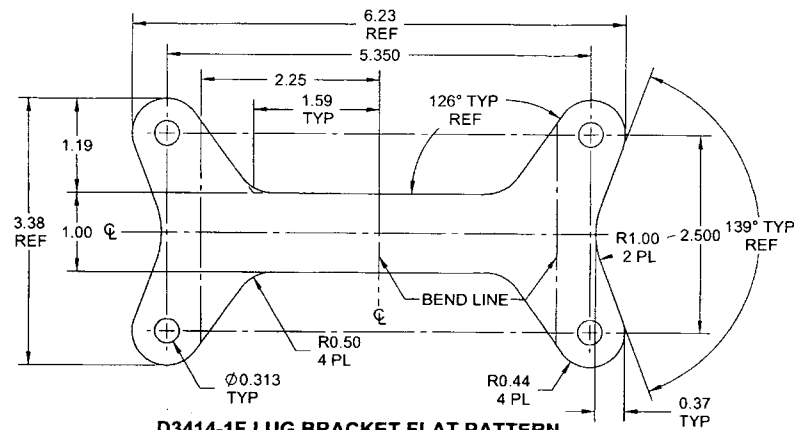
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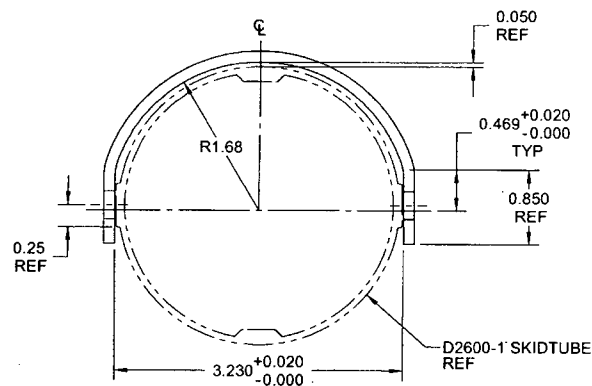
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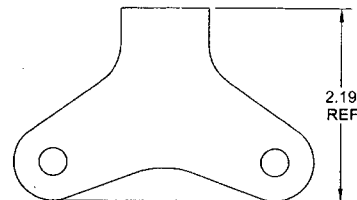
NOTE: Date & initial all entries



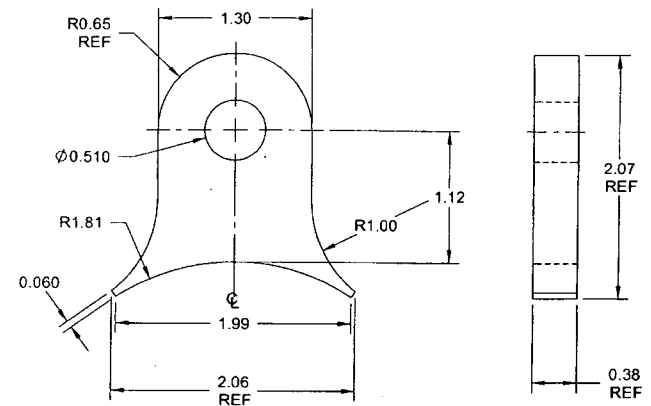
D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG

NOTES:

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

RELEASED

DESIGN	QP	DART AEROSPACE LTD	
DRAWN	QP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
CANADA

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 904284

Date: 23-May-12

To

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

Ship To

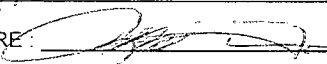
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
119 ea	Part: D3278-1P SUPPORT, SIDE 1 Job: 12892	Rev: C PO: PO16887	Line: 1 & 5
120 ea	Part: D3278-2P SUPPORT, SIDE 2 Job: 12893	Rev: C PO: PO16887	Line: 2 & 6
58 ea	Part: D3404-1P GHW LUG Job: 12894	Rev: C PO: PO16887	Line: 3
58 ea	Part: D3414-3P LUG ASSEMBLY Job: 12895	Rev: C PO: PO16887	Line: 4
DATE: 23/05/12			
CERTIFIED SIGNATURE: 			
RECEIVER SIGNATURE: _____			
CERTIFICATE OF CONFORMANCE			
A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT ARE IN CONFORMANCE WITH THE REQUIREMENTS, SPECIFICATIONS, AND DRAWINGS REFERENCED IN THE ABOVE PURCHASE ORDER.			
I.S.O. 9001 : 2008 REGISTERED / MADE IN CANADA			